

Work Order ID 71444

Monday, July 04, 2011 1:04:40 PM



Page 1

Item ID: D4154-1

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 7/5/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-07-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4154	B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

MR VET FULL EX

B11-7-5

(8)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-7-5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan: --

Date: --

Tooling: --

Date: --

Run Start



QC: --

Date: --

SPC (Y/N): --

Date: --

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SB 6/27/11

(X8)

130

Form as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 11/07/11

(8)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/07/11

(CS)

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Required Date: 7/19/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *W/A-*

0.00



Packaging

Memo

0.00

Packaging

*8**11-07-11 JBL*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/7/12**ME 11-07-12*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 04, 2011 1:04:38 PM

Page 1

Work Order ID: 71444

Parent Item: D4154-1

Parent Item Name: Plate




Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	104.6550	4.2697	35.95537			



B117-5

Location

Loc Qty

Loc Code

MAT020

104.655

113062

13.655

116979

69

117653

22

117653

68

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 71444
Description: Plate		Part Number: D4154-1
Inspection Dwg: D4154 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	4.01	X		V B02	
0.450	+/-0.010	-4.56	X		V	
0.125	+/-0.010	-1.29	X		V	
0.88	+/-0.030	.88	X		V	
1.19	+/-0.030	1.19	X		V	
5.273	+/-0.010	5.273	X		V	
2.75	+/-0.030	2.75	X		V	
15.80	+/-0.030	15.80	X		T B01	
3.95	+/-0.030	3.955	X		V	
4.00	+/-0.030	4.002	X		V	
6.42	+/-0.030	6.419	X		V	
21.75	+/-0.030	21.75	X		T	
4.35	+/-0.030	4.353	X		V	
1.80	+/-0.030	1.806	X		V	
21.31	+/-0.030	21.31	X		T	
4.26	+/-0.030	4.263	X		V	
8.83	+/-0.030	8.83	X		T	
5.16	+/-0.030	5.16	X		V	
0.55	+/-0.030	.55	X		V	
91.56	+/-0.030	91.56	X		T	
90.41	+/-0.030	90.41	X		T	
74.45	+/-0.030	74.45	X		T	
66.51	+/-0.030	66.51	X		T	
48.59	+/-0.030	48.59	X		T	
40.76	+/-0.030	40.76	X		T	
15.45	+/-0.030	15.45	X		T	
5.223	+/-0.010	5.221	X		T	
Ø0.516	+0.008/-0.001	.522	X		V	
Ø0.188	+0.005/-0.001	.190	X		V	
0.050	+/-0.010	.045	X		V	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 11-7-5	Date: 11/07/06	Date:

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
b	11.04.28	Dimensions updated per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
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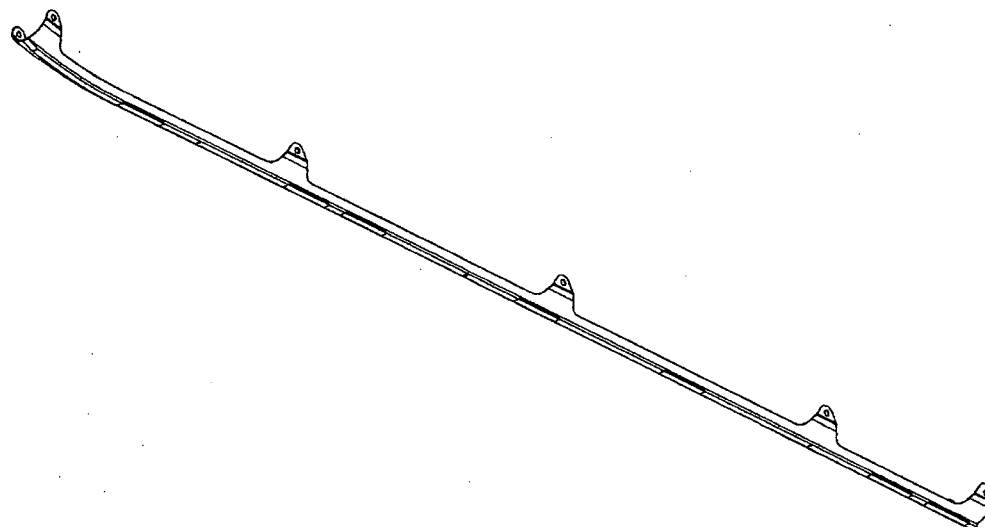
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13

B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F		MB	11.04.05
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN	5	PORT HADLOCK, WA		
CHECKED	11/4	DRAWING NO.	REV. B	
MFG. APPR.	11/4	D4154	SHEET 1 OF 3	
APPROVED	11/4	TITLE	SCALE	
DE APPR.	11/4	WEARPLATE ASSEMBLY	NTS	
DATE	11.04.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>		

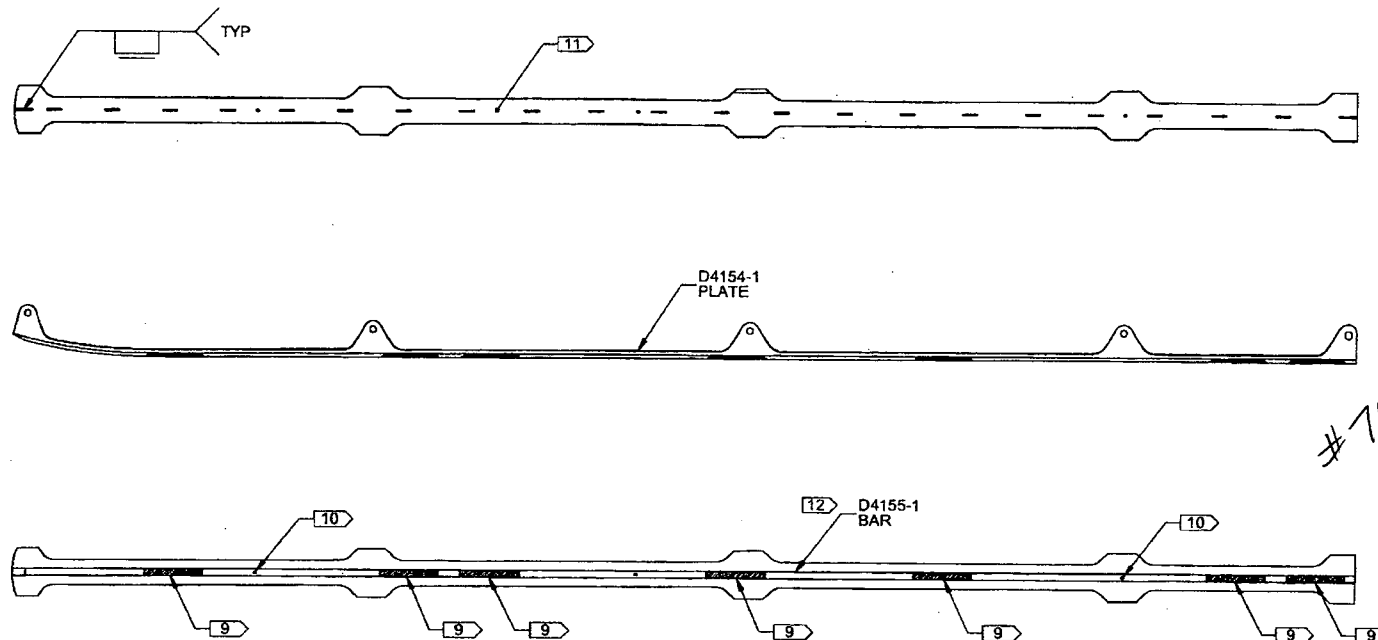
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

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MFG. APPR.	MD	D4154	SHEET 2 OF 3
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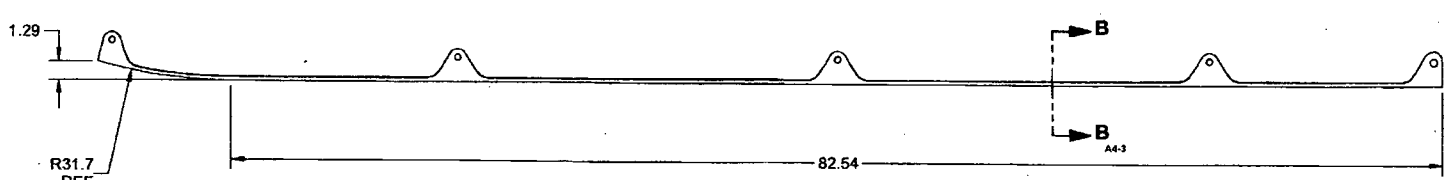
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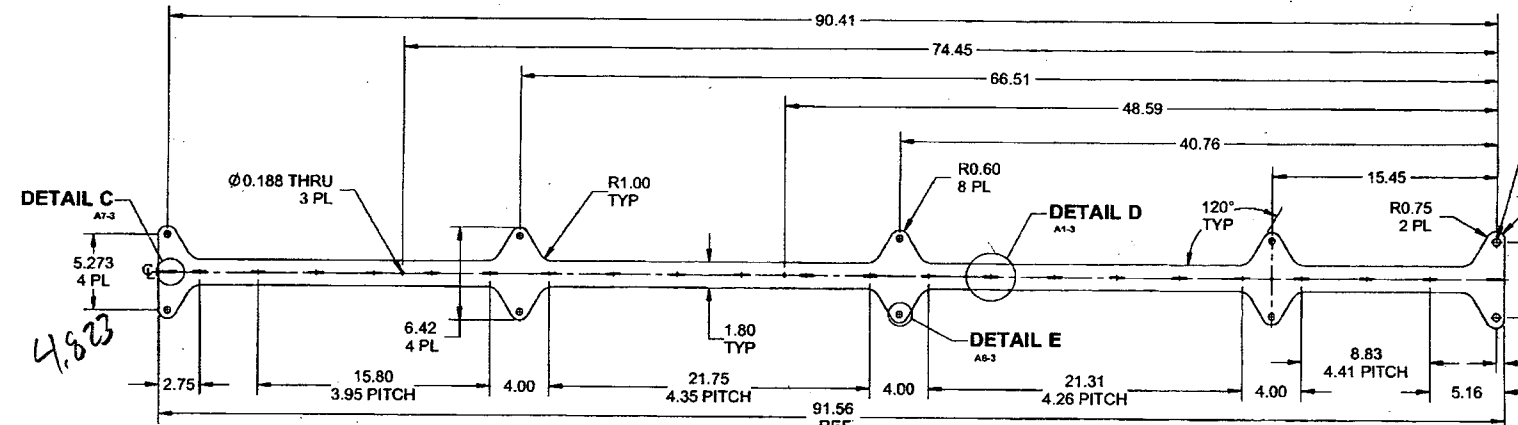
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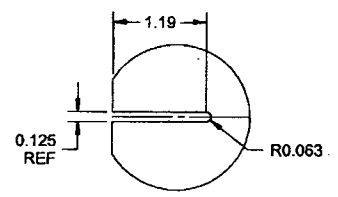
8 7 6 5 4 3 2 1



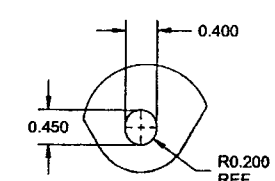
D4154-1 PLATE
(MAKE FROM D4154-1F)



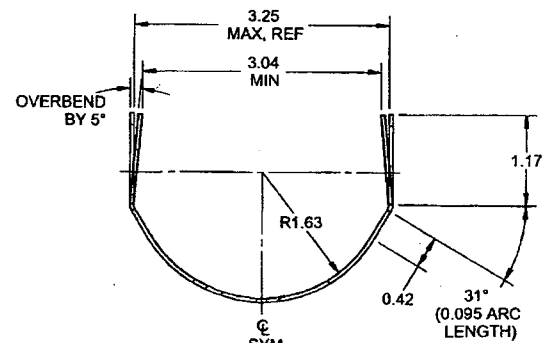
D4154-1F FLAT PATTERN



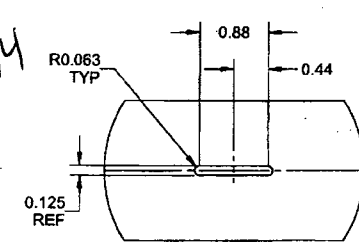
DETAIL C
END SLOT DETAIL, 2 PL



DETAIL E
SLOT DETAIL TYP



SECTION B-B



DETAIL D
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.95 lbs

RELEASED
2011-04-13

4.702

#71444

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	B	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4154	SHEET 3 OF 3
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Dart Aerospace Ltd

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